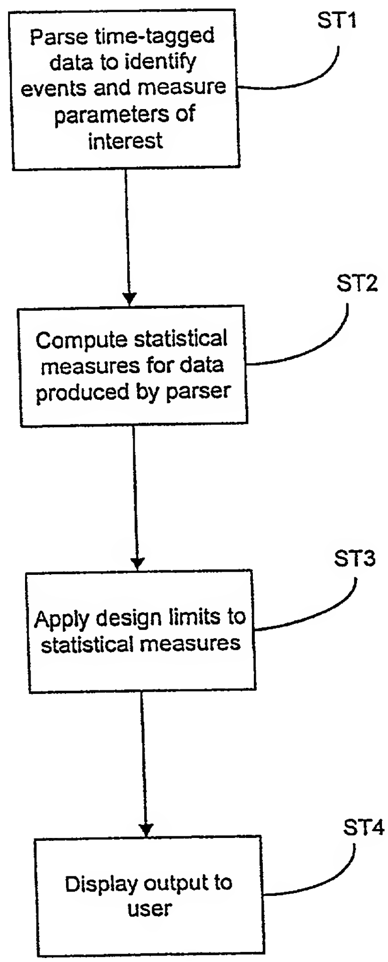

FIG. 1

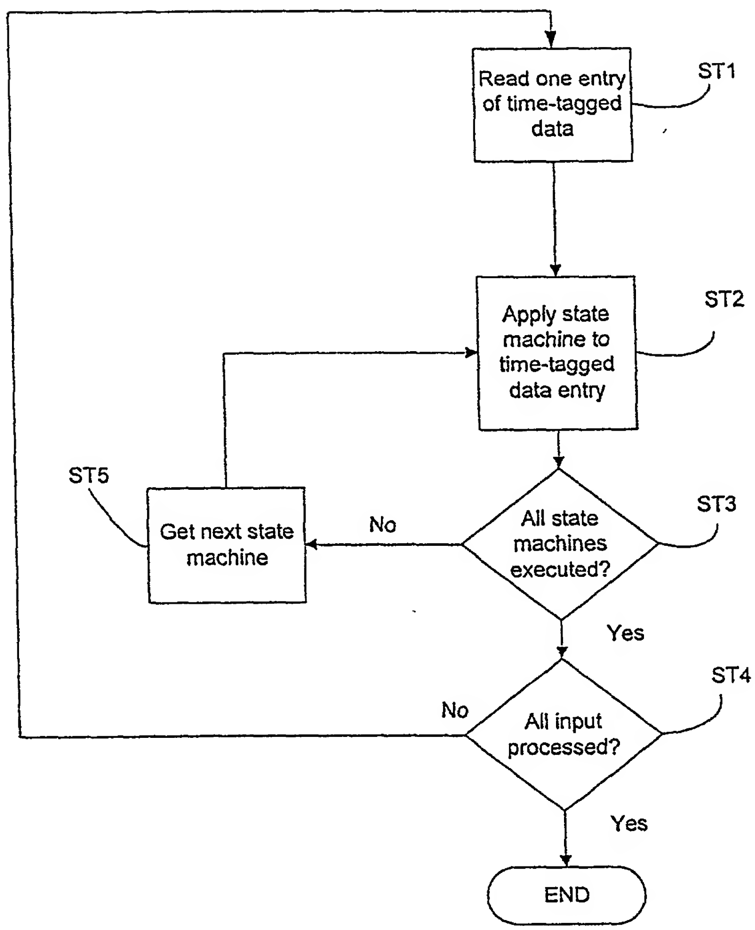

FIG. 2

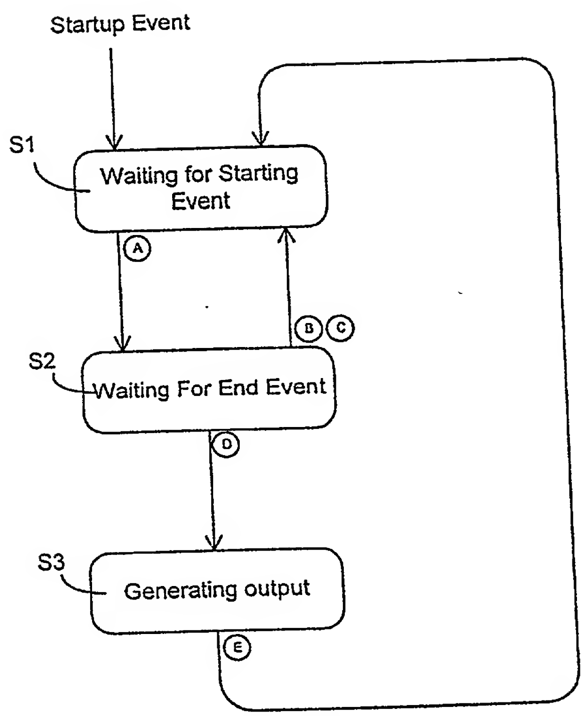

FIG. 3

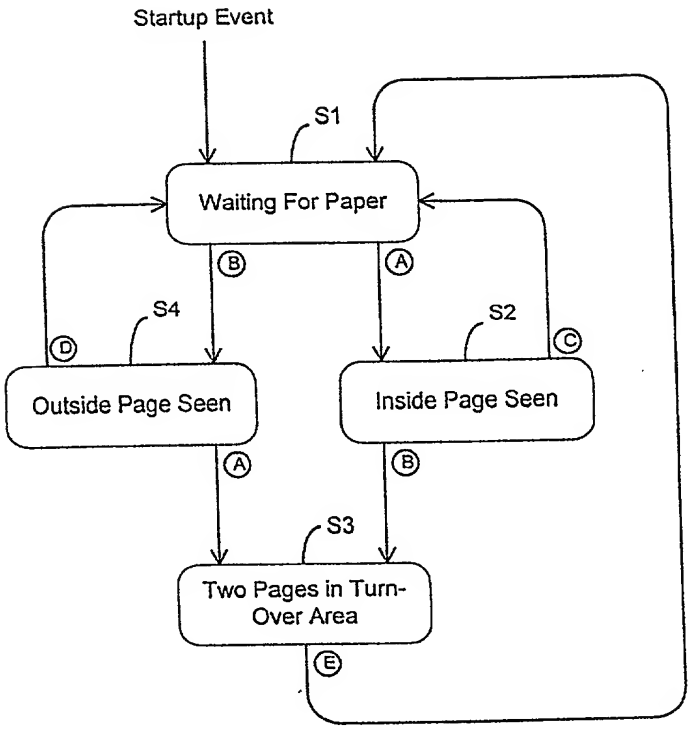
Startup Event
S1
Waiting For Paper
B
A
S4
S2
D
C
Outside Page Seen
Inside Page Seen
A
B
S3
Two Pages in Turn-Over Area
E

FIG. 4

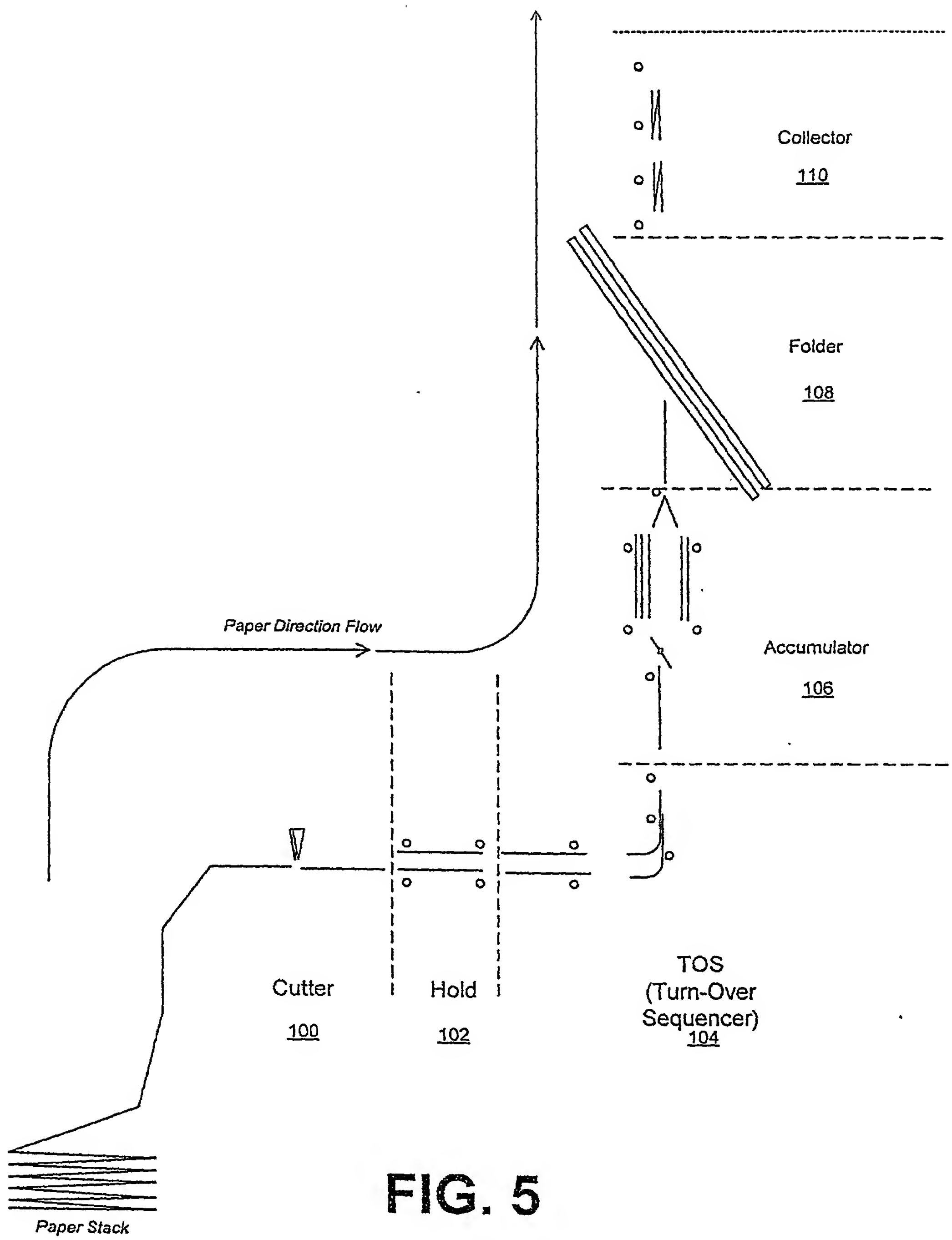

FIG. 5

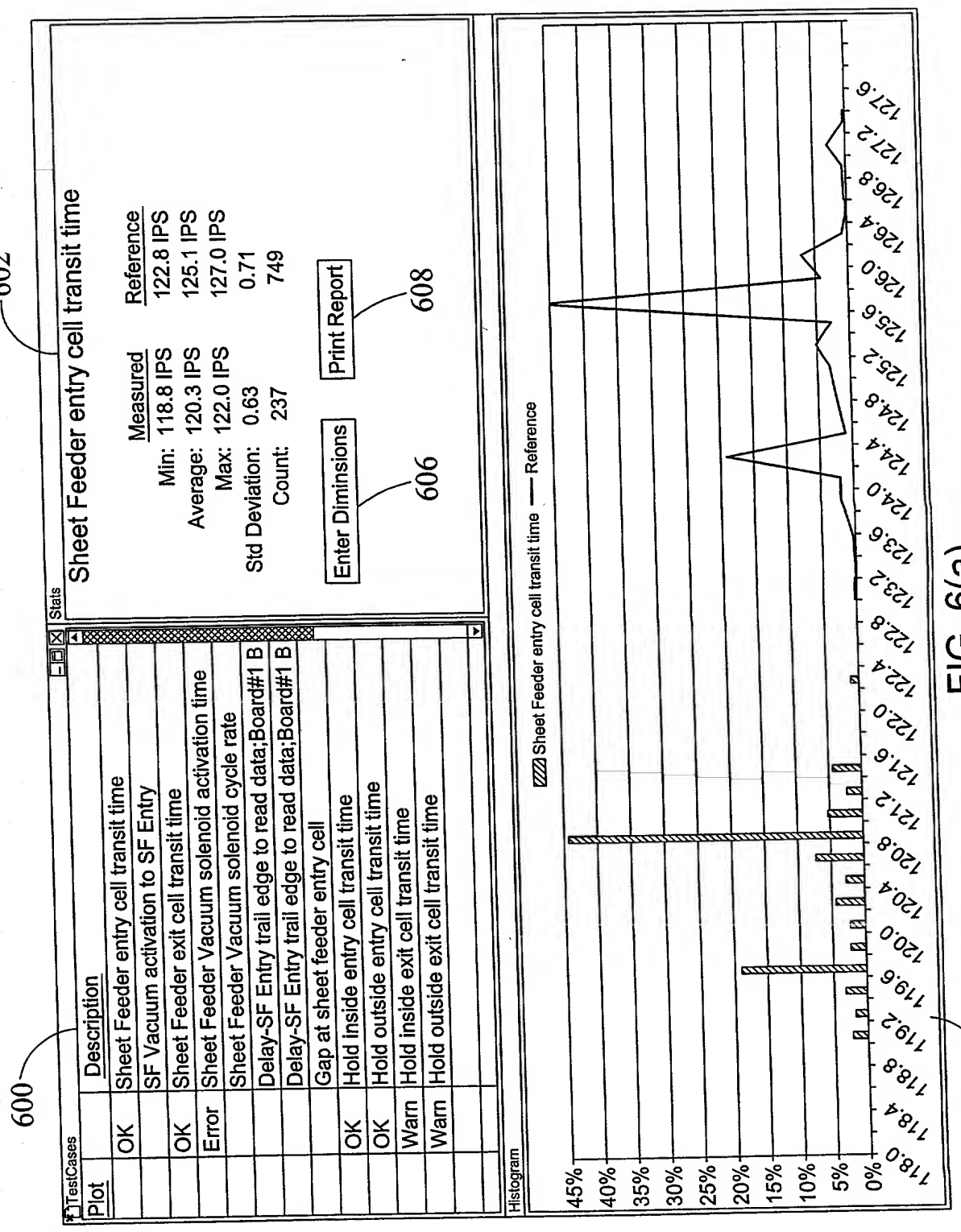
600
602
TestCases
Plot
Description
OK Sheet Feeder entry cell transit time
SF Vacuum activation to SF Entry
OK Sheet Feeder exit cell transit time
Error Sheet Feeder Vacuum solenoid activation time
Sheet Feeder Vacuum solenoid cycle rate
Delay-SF Entry trail edge to read data;Board#1 B
Delay-SF Entry trail edge to read data;Board#1 B
Gap at sheet feeder entry cell
OK Hold inside entry cell transit time
OK Hold outside entry cell transit time
Warn Hold inside exit cell transit time
Warn Hold outside exit cell transit time
Stats
Sheet Feeder entry cell transit time
Measured
Reference
Min: 118.8 IPS 122.8 IPS
Average: 120.3 IPS 125.1 IPS
Max: 122.0 IPS 127.0 IPS
Std Deviation: 0.63 0.71
Count: 237 749
Enter Diminsions
Print Report
606
608
Histogram
Sheet Feeder entry cell transit time
Reference
45%
40%
35%
30%
25%
20%
15%
10%
5%
0%
118.0
118.4
118.8
119.2
119.6
120.0
120.4
120.8
121.2
121.6
122.0
122.4
122.8
123.2
123.6
124.0
124.4
124.8
125.2
125.6
126.0
126.4
126.8
127.2
127.6
604

FIG. 6(a)

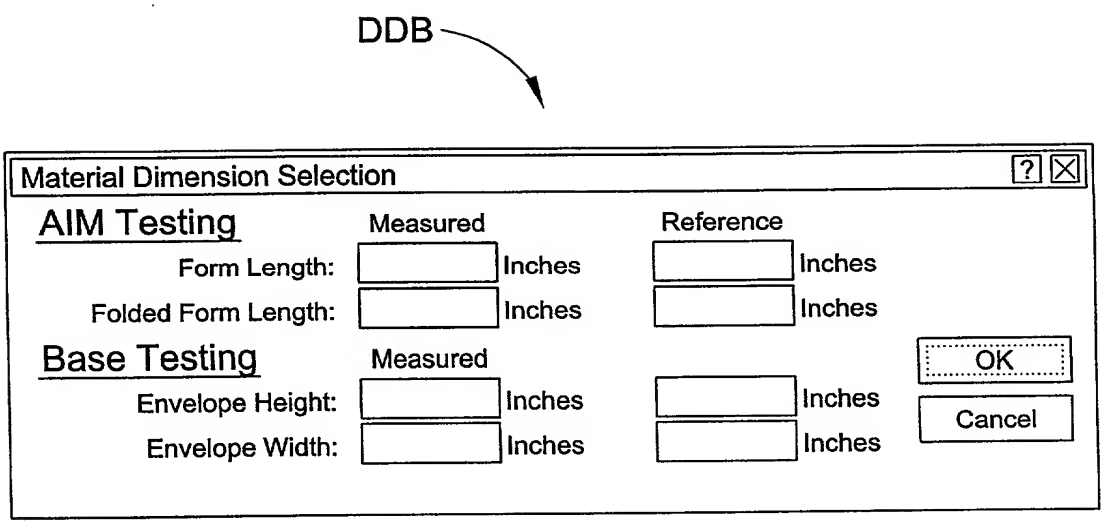

FIG. 6(b)

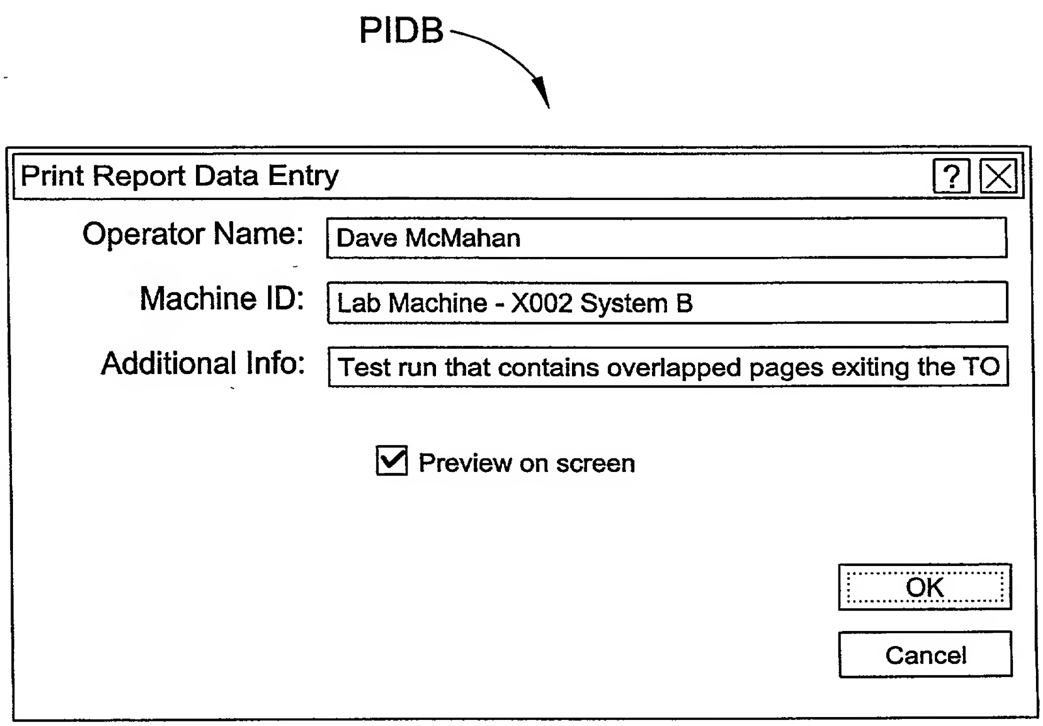

FIG. 6(c)

TAAS Data File Name : C:\bhwrulz\pbidrulz\example.trc
Operator : Dave McMahan
Machine Identifier : Lab Machine - X002 System B

9/30/99

Additional Info : Test run that contains overlapped pages exiting the TOS

Form Length : 11.00 Inches

Item Description	Minimum	Average	Maximum	Std Dev	Count	Status
1) Sheet Feeder entry cell transit time	122.8 IPS	125.1 IPS	127.0 IPS	0.7	1498	OK
2) SF Vaccuum activation to SF Entry	35.3 mSec	39.6 mSec	44.5 mSec	1.5	1498	
3) Sheet Feeder exit cell transit time	94.1 IPS	127.0 IPS	130.3 IPS	1.5	1496	Error
4) Sheet Feeder vacuum solenoid activation time	36.8 mSec	41.0 mSec	46.1 mSec	1.5	1498	
5) Sheet Feeder vacuum solenoid cycle rate	8,910.7 CPH	19,358.8 CPH	26,344.7 CPH	559.2	1497	
6) Gap at sheet feeder entry cell	47.0 mSec	96.7 mSec	314.9 mSec	8.8	1496	
7) Hold inside entry cell transit time	118.9 IPS	120.7 IPS	122.4 IPS	0.6	1496	OK
8) Hold outside entry cell transit time	119.2 IPS	121.0 IPS	123.2 IPS	1.1	1496	OK
9) Hold inside exit cell transit time	117.8 IPS	119.6 IPS	120.9 IPS	0.5	1495	OK
10) Hold outside exit cell transit time	50.1 IPS	119.8 IPS	121.0 IPS	2.6	1494	OK
11) TOS Entry Inside-to-Outside lead edge difference	2.7 Inches	3.5 Inches	4.1 Inches	0.4	48	
12) TOS inside entry transit time	132.6 IPS	135.2 IPS	136.2 IPS	0.8	82	
13) TOS outside entry transit time	133.5 IPS	135.0 IPS	136.2 IPS	0.8	82	
14) TOS outside turn transit time	131.9 IPS	133.2 IPS	136.1 IPS	0.8	82	
15) TOS inside turn single page transit time	135.2 IPS	136.6 IPS	139.3 IPS	1.0	68	
16) TOS exit single page transit time	143.2 IPS	144.8 IPS	147.2 IPS	1.0	67	
17) Accum gate single page transit time	153.3 IPS	156.1 IPS	159.9 IPS	1.2	68	
18) Accum lower cnt single page transit time	171.3 IPS	173.3 IPS	174.3 IPS	1.2	34	
19) Accum upper cnt single page transit time	168.6 IPS	171.0 IPS	174.0 IPS	1.4	34	
20) TOS inside turn page overlap	5.1 Inches	5.9 Inches	6.5 Inches	0.4	48	
21) TOS exit page overlap	4.9 Inches	5.7 Inches	6.3 Inches	0.4	48	
22) Accum gate page overlap	4.0 Inches	5.2 Inches	5.9 Inches	0.5	48	
23) Accum upper cnt page overlap	3.5 Inches	4.6 Inches	5.2 Inches	0.5	16	
24) Accum lower cnt page overlap	3.6 Inches	4.9 Inches	6.1 Inches	0.7	32	
25) Lower Accum Clutch Release to Exit Cell	44.0 mSec	44.9 mSec	46.0 mSec	0.5	34	
26) Upper Accum Clutch Release to Exit Cell	44.8 mSec	46.2 mSec	48.3 mSec	0.7	33	
27) Rate at which Sets Leave Accumulator	171.9 mSec	432.5 mSec	2,268.5 mSec	267.1	67	Warn
28) Accum Exit Cell Transit Time	126.6 IPS	128.5 IPS	130.2 IPS	0.9	68	Warn
29) Folder Transit Time	53.9 mSec	55.2 mSec	57.6 mSec	0.6	68	
30) Collector Input Cell Arrival Rate	171.8 mSec	432.5 mSec	2,268.5 mSec	267.0	67	Warn
31) Collector Input Cell Transit Time	31.3 mSec	32.5 mSec	33.9 mSec	0.5	68	
32) Collector Dump Cell Transit Time	30.7 mSec	32.7 mSec	36.5 mSec	1.4	64	
33) Collector output dump rate	1,487.5 CPH	9,316.0 CPH	14,076.2 CPH	2,227.3	63	

Warnings and Errors List
3) Error: Lowest value is below limit of 100 IPS
27) Warning: Lowest value is close to lower limit of 170 mSec
28) Warning: Highest value is close to upper limit of 131 IPS
30) Warning: Lowest value is close to lower limit of 170 mSec

FIG.6(d)